

Date: Wednesday, 3/14/2007 12:24:58 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L/L 1/L3 SCUFF PLATE, FWD LH
Job Number	: 31184		
Estimate Number	: 12268		
P.O. Number	: <i>N/A</i>	Part Number	: D206555005
This Issue	: 3/14/2007 / S.O. No. : <i>N/A</i>	Drawing Number	: D206-555 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 30364	Material	: <i>N/A</i>
Written By	: <u><i>[Signature]</i></u>	Due Date	: 3/30/2007 Qty: 10 Um: Each
Checked & Approved By	: <u><i>[Signature]</i></u>		
Comment	: Est C 99.86.29 Returned to Electro Polish DM Est Rev:D Now On Waterjet 07-01-22 JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Type Labels as per PPP D206-555-005

2.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.4610 sf(s)/Unit Total : 4.6100 sf(s)
 304/316 .020" Sheet
 Batch: *M102393*

SAD 07/04/07

(10)

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D206-555
 Dwg Rev: *C*
 Prog Rev: *C*

SAD 07/04/07

(10)

2-Deburr if necessary

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/07

(10)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:24:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD LH

Job Number: 31184

Part Number: D206555005

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8318-5

Finish form on bench forming Jig DT 8319-5

803 07/04/10

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0704.11 (10)

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 3507

Possible supplier: TQF Technologies

0707/04/11 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

0704/24 (10)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

N/A

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/4/24 SQ

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PA Date: 21/04/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:24:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD LH

Job Number: 31184

Part Number: D206555005

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/4/24 SD

10

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/04/25

15

Job Completion



W 07-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

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06.09.19 RETURN TO
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WITHOUT NOTICE

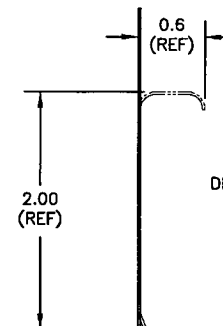
WORK ORDER

NO. 31184

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FLAT PATTERN



SECTION A-A
DETAIL OF BENDING
SHOWN

2.7
(REF)

8.000

Ø0.187
(2 PLACES)

14.1
(REF)

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WORK ORDER
NO. 31184

D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)
D206-555-002 (BEND OPPOSITE)

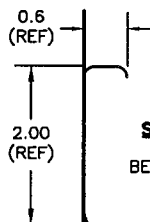
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.04.19

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED JB	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



SECTION C-C
DETAIL OF
BENDING SHOWN

DETAIL B
SCALE 1:1

REFER TO DETAIL B
FOR 1:1 SCALE

16.000 (REF)

2.7
(REF)

FLAT PATTERN

8.000

19.0
(REF)

8.000

Ø0.187
(3 PLACES)

RELEASED

06.09.19-11

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)

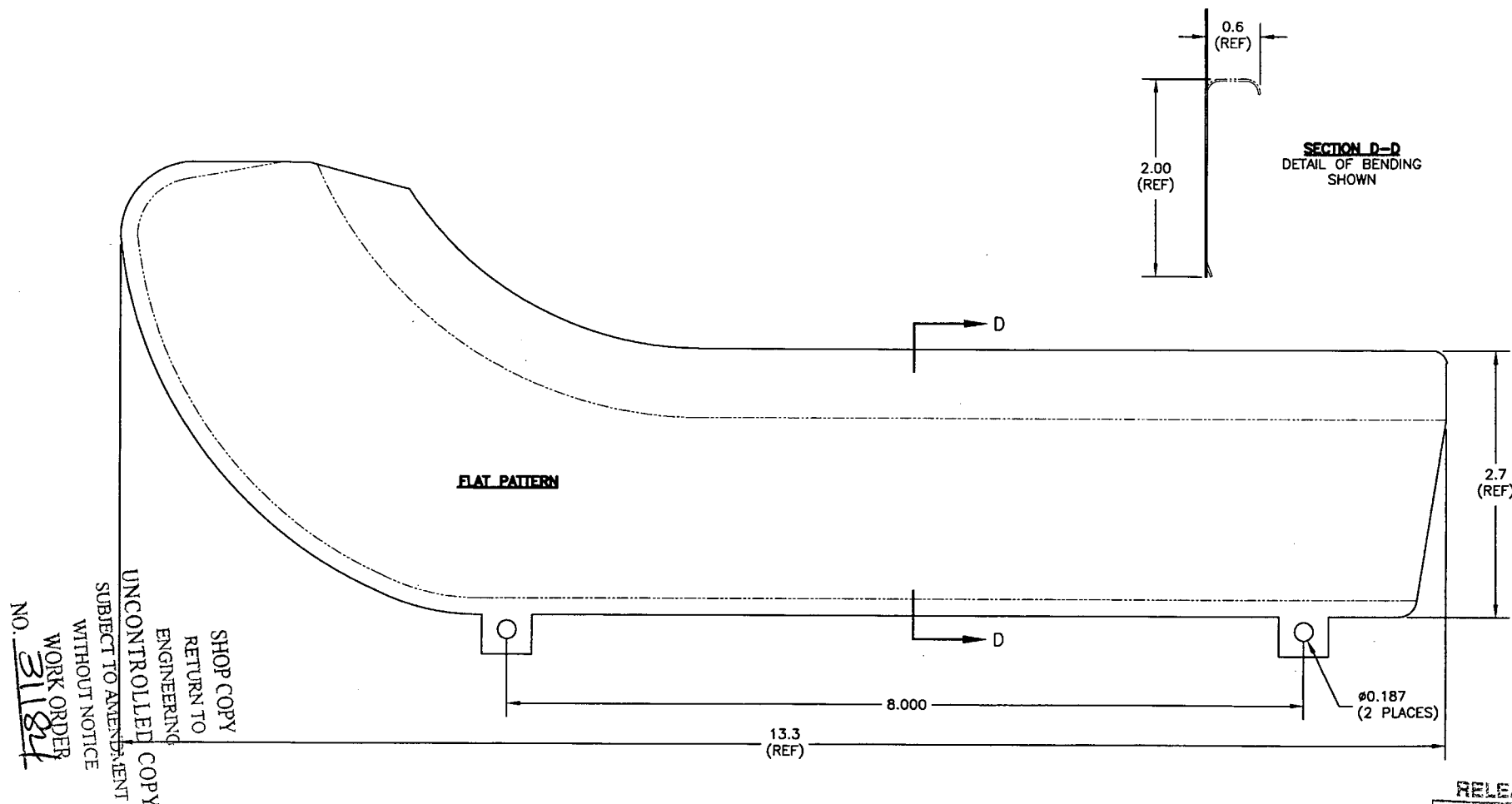
D206-555-004 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED BY PH	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	

NO. 3184
 WORK ORDER
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D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

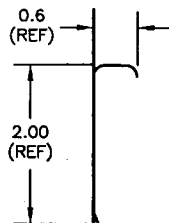
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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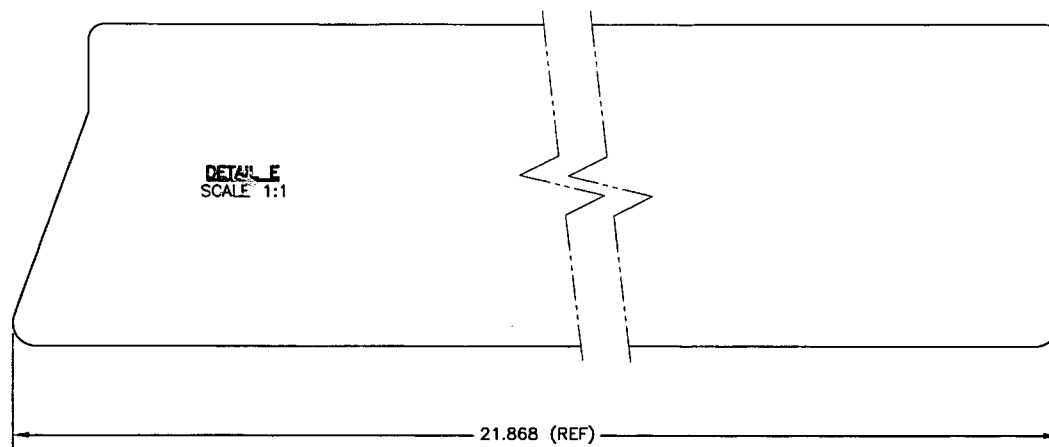
06-09-19

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED JB	DRAWING NO. D206-555	SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



SECTION F-F
DETAIL OF
BENDING SHOWN

DETAIL E
SCALE 1:1



REFER TO DETAIL E
FOR 1:1 SCALE

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FLAT PATTERN

FLAT PATTERN

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

NOTES

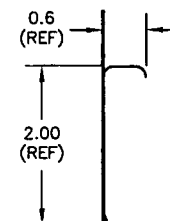
- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.19 #

DESIGN JB	DRAWN BY B	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED H	DRAWING NO. D206-555	SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	

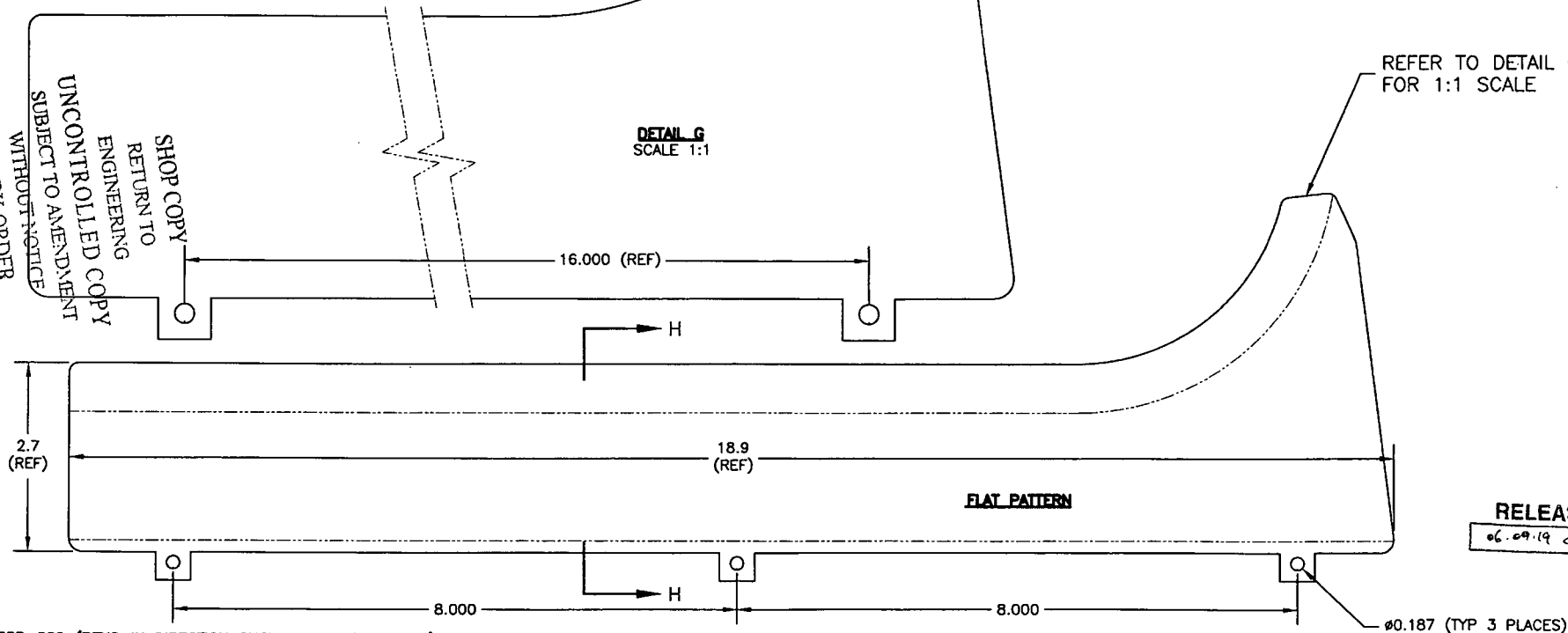
WORK ORDER
NO. 31184
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SECTION H-H
DETAIL OF
BENDING SHOWN

REFER TO DETAIL G
FOR 1:1 SCALE

DETAIL G
SCALE 1:1



RELEASED

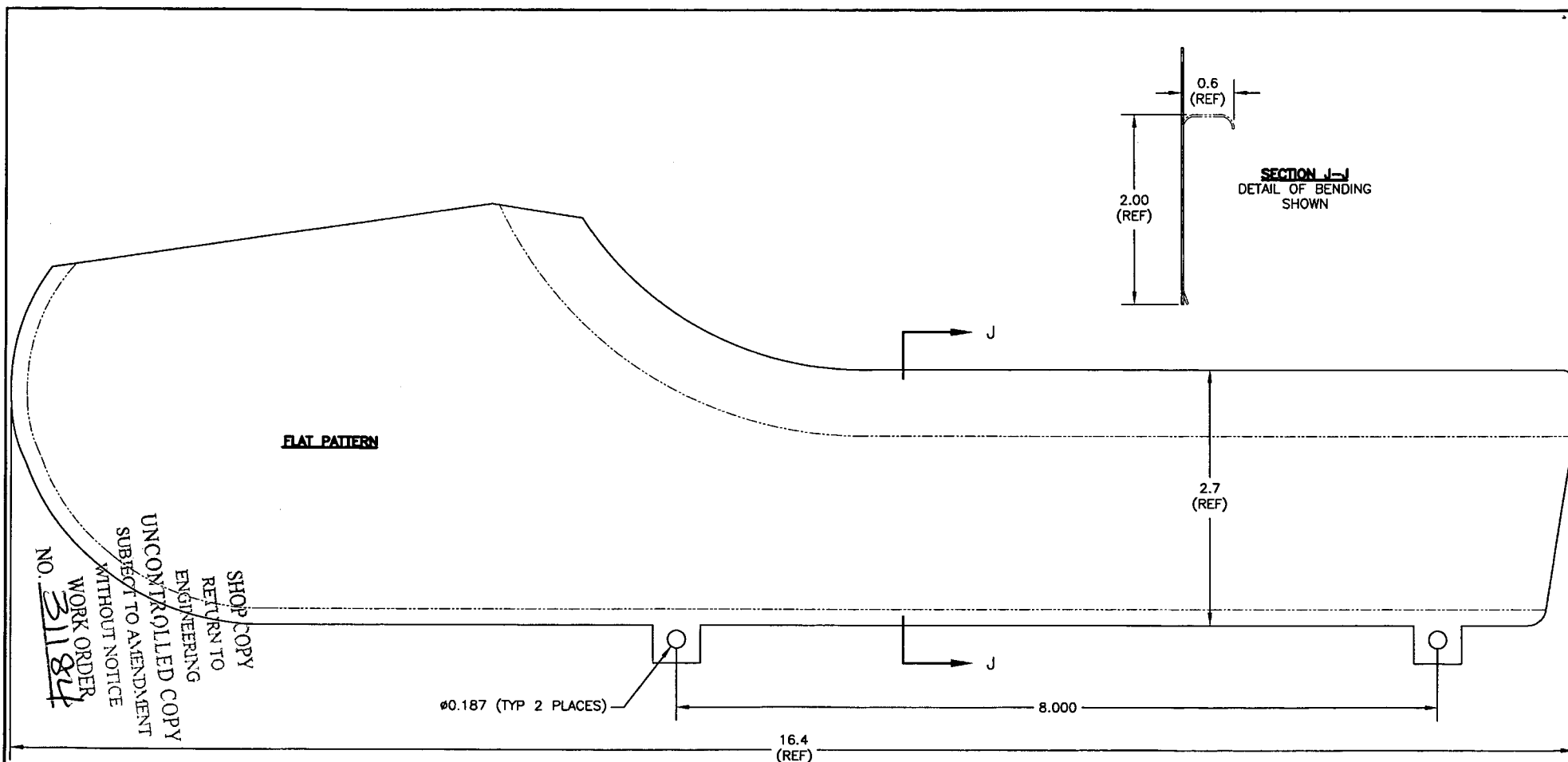
06.09.19

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD
JB	JB		WINDSOR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. C
PH	PH	D206-555	SHEET 6 OF 7
DATE	TITLE	SCALE	
06.09.01	DOOR SILL SCUFF PLATES	2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)

D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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06-09-19

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 7 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1

DART AEROSPACE LTD		Work Order: 31189
Description:		Part Number: D206555 005
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	13.3	+/- 0.030	13.28	✓		Vertical Vern	
B	8.00	+/- 0.030	7.999	✓		Vern	
C	Ø 0.187	+ 0.005 - 0.001	Ø 0.187	✓		Vern	
D	2.7	+/- 0.030	2.702	✓		Vern	
E							
F							
G							
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAN	Audited by: Sp	Prototype Approval:	N/A
Date: 07/04/07	Date: 07/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	



INVOICE

SOLD TO

DART AEROSPACE LTD.

**1270 ABERDEEN ST
HAWKESBURY, ONTARIO
K6A 1K7**

attn. Accounts
Payable

SHIPPED TO

DART AEROSPACE LTD.

**1270 ABERDEEN ST
HAWKESBURY, ONTARIO
K6A 1K7**

CUSTOMER N°	G.S.T. N°	Q.S.T. N°	DATE OF INVOICE	INVOICE N°
0434	13918 6787 RT0001	1017125792-TQ0001	April 18, 2007	F 103576
ORDER DATE	CUSTOMER ORDER N°	FREIGHT	F.O.B.	TERMS
April 12, 2007	3507	PP	ST-LAURENT	N 30

Job N°	Qty	Description	Pricing	Amount
125832	10	D206-555-005 B31184	10 unit(s) \$12.60 ea	\$126.00

Certification No C114949

S-TOTAL ----- \$126.00
G.S.T. (6%) ----- \$7.56

Amount Due \$Cdn \$133.56

CUSTOMER RETURN

Initiator: Jean Kerr
 Company: Alpine AeroTech Ltd
CALP102
 Phone No: 250-769-6344

Date: March 11/00
 Invoice # 3957
 Order Entry # 3421

Attach Copy of DHS Return Authorization # 379

Reason for return: Plates not fitting. Wishes A replace - product on hold
AS per Peggy.

Receiving:

Date Received: 8/3/13 Freight Company: FIDELITY Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-555-005	31184	Scuff Plate End Lt.	DATE	8/3/14
1	D206-555-006	30365	Scuff Plate End R/L		

Condition of packaging: GW Photograph required: yes no

Paperwork attached: P/S P Invoice ARC Docs Other

QC:

Quarantine: Location: Condition of Part: good/in bag

Inspect: Initial: chg002

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-555-005	B31184	Place under quarantine as	<u> </u>	38035	
1	D206-555-006	B30365	per W/O		38036	

QA Coordinator:

Advise GM as to findings: Initial: Date:

Comments:

Issue credit: yes no

GM Approval: Date:

Invoice Amount:
 Less Replacement:
 Restock Fee:
 Freight:
 Net Credit:
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

CUSTOMER RETURN

Initiator: Jean Kerr
 Company: TAIGA Air Services
CTAIG01
 Phone No: 204-943-3645

Date: March 2006
 Invoice # 5053
 Order Entry # 4953

Attach Copy of DHS Return Authorization # 376

Reason for return: Plates do not fit

Receiving:

Date Received: 8/3/19 Freight Company: Prolog Prepaid ☐ Collect ☐

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-555-006	31605	Schiff plate RH	DATE	8/3/19
1	D206-555-005	31184	LT		

Condition of packaging: Good Photograph required: yes ☐ no ☒

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC:

Quarantine: Location: Condition of Part: good

Inspect: Initial:

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-555-006	31605	Quarantine per W/O - UCR	<u> </u>	38117	
1	D206-555-005	31184			38118	

QA Coordinator:

Advise GM as to findings: Initial: Date:

Comments:

Issue credit: yes ☐ no ☐

GM Approval: Date:

Invoice Amount:
 Less Replacement:
 Restock Fee:
 Freight:
 Net Credit:
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit